



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7703
Job Sheet 203282



Part No: 647.7703

Job Qty: 10 pcs

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/19

Job Tracking No:

Due Date: 12/13/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A2 IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Large Fab - Welded Assy-1	10 pcs	12/13/19	12/13/19	0.00	3.95	Large Fab - 1		MV Feb 25/20
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
130	QC 9	10 pcs	12/13/19	12/13/19	0.00	0.00	QC 9 - 10		DAS 24 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
140	QC 5	10 pcs	12/13/19	12/13/19	0.00	0.00	QC 5 - 10		DAS 24 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



Dart Aerospace
1270 Aberdeen St
Hawkesbury, ON K6A
CANADA
TEL: 1 613 632-5200
Email: sales@dartae
www.dartaerospace.ca

Container No: S258056



Part No: 647.7703

Job No: 203282

Serial No/Batch: S258056

Revision: Rev A2

Director:

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					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	DAS
					QC 14 - 40	81
					QC 14 - 19	9-89
					QC 14 - 43	
					QC 14 - 24	MAR 13 2020
					QC 14 - 61	
					QC 14 - 81	
200	Packaging 3-1 - Stock - B4B	10 pcs	12/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	DA
					Packaging 3 - 5 - B4B	2
					Packaging 3 - 6 - B4B	9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210	QC 21 - SA	10 pcs	12/13/19	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	202
Part Op 120 - Weld per dwg A/R 4130 rod Batch: <u>M127125</u> - 1- ASSEMBLE AND WELD AS PER DWG ***IMPORTANT Descriptions: DIMENSION IS 8.35" *** 130 - QC9- Inspect visual per QSI004- Fusion Welds 140 - QC5- Inspect part completeness to step on W/O 150 - Issue P/O : <u>45978</u> Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II ****NOTE: limite cad platting on thread to 0.003" or less**** 160 - Receive & Inspect for Damage & Mat'l Certs 170 - INSPECT USING GO/NO GO GAUGE 180 - Spray Paint / NDT Room - PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG <u>5236137</u> 190 - QC14- Inspect Spray Paint 200 - Identify as per dwg & Stock Location: _____ 210 - QC21- Final Inspection - Work Order Release						

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.7712	Strut Tube	10 pcs (1 ea)	120-Large Fab - Welded Assy-1	5256207
647.7713	Strut Thread	10 pcs (1 ea)	120-Large Fab - Welded Assy-1	5256860
647.7714	Strut Tube	10 pcs (1 ea)	120-Large Fab - Welded Assy-1	5237202

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Large Fab - Welded Assy-1	647.7712	10	17	0
	647.7713	10	10	0
	647.7714	10	8	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045978



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045978
PO Date: 2/28/20
Due Date: 3/9/20
**Purchase Order
Revision:**
Revision Date:
Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments:

EMAILED
2020-03-02

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	205006	647.7701	647.7700 Rev A2	Strut Assembly : Various STC's Issue P/O CAD PLATE IAW QQ- P-416F CLASS I TYPE II Material 4130; RC 33 - NO baking required note: cad plate should not be too thick around tread	Firmed X30	-	3/9/20	30 pcs	0 pcs	30 pcs	\$14.16/pcs	\$424.80
	205084				Firmed X11 MAR 10 2020	-	3/9/20	11 pcs	0 pcs	11 pcs	\$14.16/pcs	\$155.76
								Sub Total:	41	0	41	\$580.56
2	205085	647.7702	647.7700 Rev A2	Strut Assembly : Various STC's Outsource3 (Outsource process- Cadplate per QSI017 4.1.9.1) Issue P/O CAD PLATE IAW QQ- P-416F CLASS I TYPE II Material 4130; RC33 - NO baking required note: cad plate should not be too thick around tread	Firmed X10	-	3/9/20	10 pcs	0 pcs	10 pcs	\$16.37/pcs	\$163.70
	205007				Firmed	-	3/9/20	30 pcs	0 pcs	30 pcs	\$16.37/pcs	\$491.10
								Sub Total:	40	0	40	\$654.80

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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045978



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	206309	647.7703	647.7700 Rev A2	Strut Assembly : Various STC's Issue P/O CAD PLATE IAW QQ- P-416F CLASS I TYPE II Material 4130; RC33 - NO baking required ****NOTE: limit cad plating on thread to 0.003" or less****	Firmed X10	-	3/9/20	10 pcs	0 pcs	10 pcs	\$12.72/pcs	\$127.20
									MAR 10 2020			
									DAS 81 9-89			
									MAR 10 2020			
	203282				Firmed X10	-	3/9/20	10 pcs	0 pcs	10 pcs	\$12.72/pcs	\$127.20
Sub Total:								20	0	20		\$254.40

Grand Total: \$1,489.76

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Guérin

Plex 3/2/20 11:25 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(026741-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

026741 - 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
09-Mar-2020		SPARTAKOS BOUNTOURIS				POHB045978				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir/ Back Order
1	647.7701 Rev.A2	647.7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2, 0.0005 " THICKNESS CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD		CADMIUM CH	30	30	0	0	0	
2	647.7701 Rev.A2	647.7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2, 0.0005 " THICKNESS CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD		CADMIUM CH	11	11	0	0	0	
3	647.7702 Rev.A2	647.7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2, 0.0005 " THICKNESS CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD		CADMIUM CH	10	10	0	0	0	
5	647-7703 Rev.A2	647-7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2, 0.0005 " THICKNESS LIMIT CAD PLATING ON THREAD TO 0.0003 " OR LESS		CADMIUM CH	10	10	0	0	0	
6	647-7703 Rev.A2	647-7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2, 0.0005 " THICKNESS LIMIT CAD PLATING ON THREAD TO 0.0003 " OR LESS		CADMIUM CH	10	10	0	0	0	

AS 81
-89

DAS 81
9-89

RECEIVED

MAR 09 2020

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.